

# Work Order ID 52763

October 14, 2009 9:08:21 AM



Page 1

Item ID: D3953-17

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: RP

Date: 09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3953

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

18 9-10-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18 9-10-22

EF 09/10/26

(24)

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Page 2

Item ID: D3953-17

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Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



QC

Quality Control

QC8- Inspect parts - second check

0.00

⇒ 809/10/06

center  
1024

4

Memo

0.00

130



Small Fab

Small Fab

Memo

1- OPEN HOLES AS PER DWG

2- DEBURR IF NECESSARY

0.00

0.00

alas

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

⇒ 809/10/06

1024

4

Memo

**Work Order ID 52763**

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Page 3

Item ID: D3953-17

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location 13S

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

49/80/26 (24)

09-10-27

NF  
09-10-27

# Picklist Print

Page 1

October 14, 2009 9:08:28 AM

Work Order ID: 52763



Parent Item: D3953-17



Parent Item Name: Gas Spring Spacer

Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	7.5800	0.6579	18000		
M304 SS bar .375 x 3.00												

189-12-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

7.58

111369

7.58

111369

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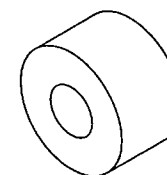
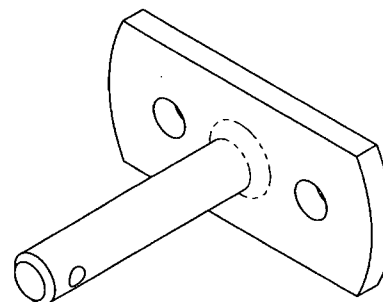
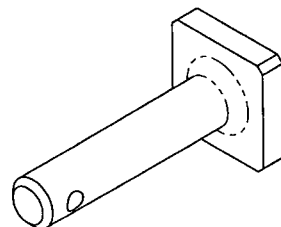
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WORK ORDER

NO. 52763

09-10-14



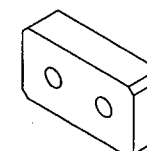
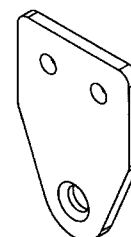
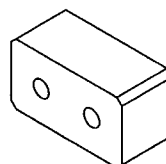
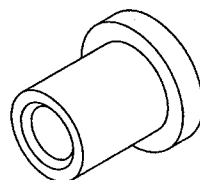
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

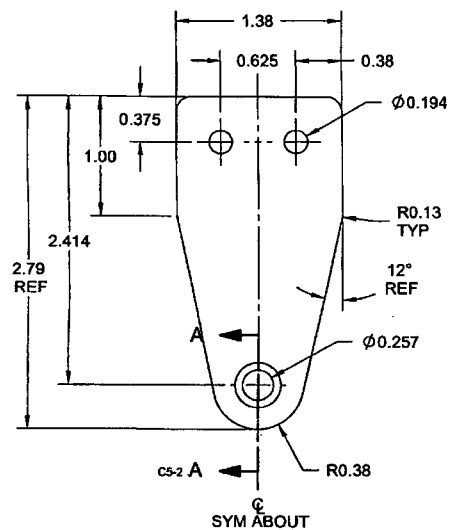
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APPROVED		DRAWING NO. D3953	SCALE
DE APPR.		TITLE	NTS
DATE	09.07.27	GAS SPRING LID COMPONENTS	

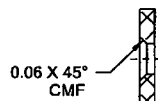
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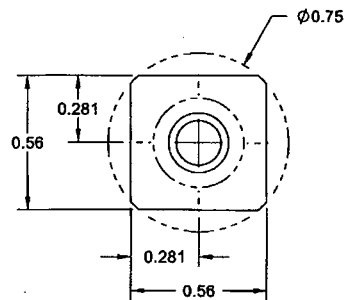
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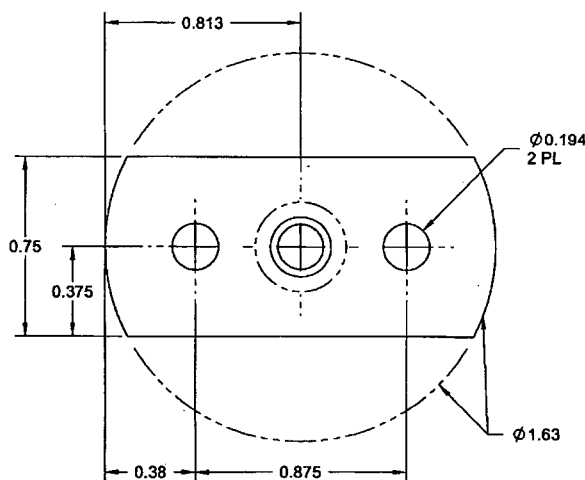
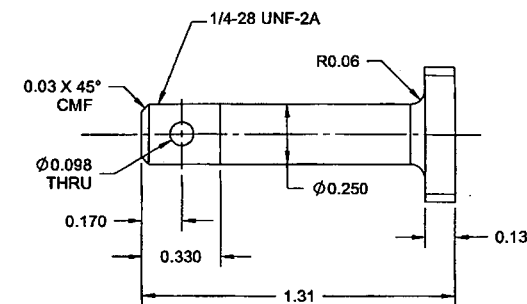
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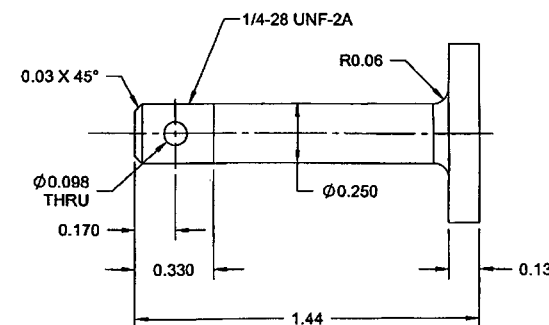
**SECTION A-A** C7-2



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



**NOTES:**

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD  
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs

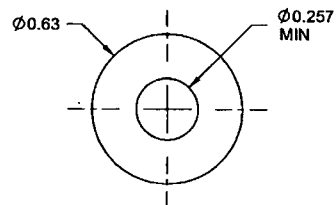
-3: 0.03 lbs

-5: 0.06 lbs

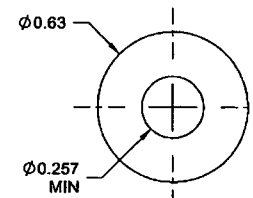
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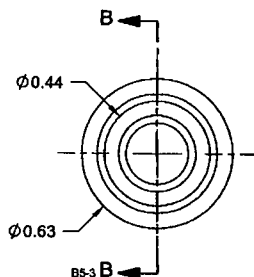
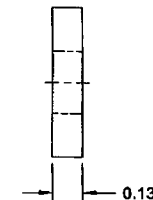
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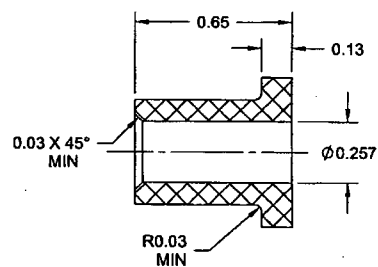
**D3953-7 GAS SPRING SPACER**



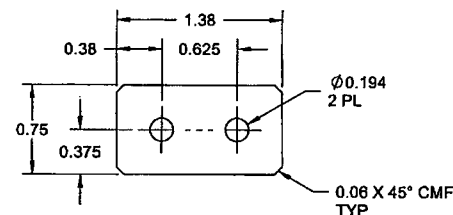
**D3953-9 GAS SPRING WASHER**



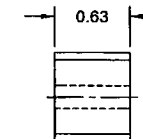
**D3953-11 GAS SPRING SPACER**



**SECTION B-B B7-3**



**D3953-13 GAS SPRING SPACER**



**NOTES:**

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

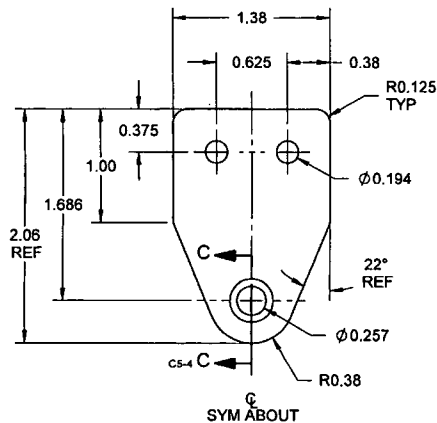
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

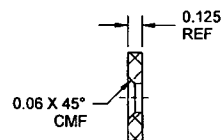
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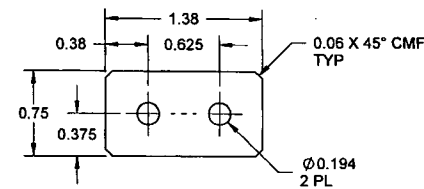
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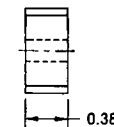
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**SECTION C-C** C7-4



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**NOTES:**

1) MATERIAL: -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT -15: 0.08 lbs  
-17: 0.10 lbs

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